

Work Order ID 75173

75173

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Item ID: D3659-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: CUFF
Start Date: 18/10/2011 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 28/10/2011 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 11/10/18 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3659	Rev B								

100 0.00
100 BAND SAW
Bandsaw Memo 0.00
Jeaspa Bandsaw Cut blank 7.300" long
13 0

110 0.00
110 DOOSAN LATHE
Doosan Memo 0.00
Doosan Lathe 1-Turn as per folio FA 707 & DWG D3659,
FOLIO REV: 4A
DWG REV: 3
2-Deburr as required
13 0

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control
13 0

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WORK ORDER CHANGES

W/O:						Approval	Approval
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Chief Eng / Prod Mgr	QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:						Verification	Approval	Approval
DATE	STEP	Description of NC Section A	Corrective Action Section B			Section C	Chief Eng	QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/17	10	the .386" hole oversized the drill clogged with chips R.C. process		scrap and destroy replace Qty 1 Batch 65179	11/01/19			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00		B.A 11/10/19		13	4		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				13	BR	11-10-19	
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

13 X 4 m 11/10/19

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WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

(137) SP11-10-19

11/10/19
 MF
 11-10-19

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75173

75173

Parent Item: D3659-1

D3659-1

Parent Item Name: CUFF

Start Date: 18/10/2011

Required Date: 28/10/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129		Manufactured	No			100	Each	16.0000	0.619	7.818947			

D6009-129

Crosstube Material

Location

Loc Qty

Loc Code

LG

16

✓ 65179

16

7.82

28/10/19

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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WORK ORDER NON-CONFORMANCE (NCR)

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DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.10.06	New Issue	KJ	AA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					Approval	Approval
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Chief Eng / Prod Mgr	QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

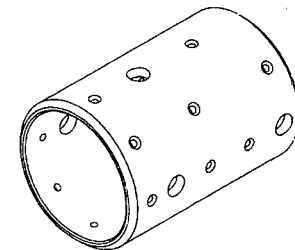
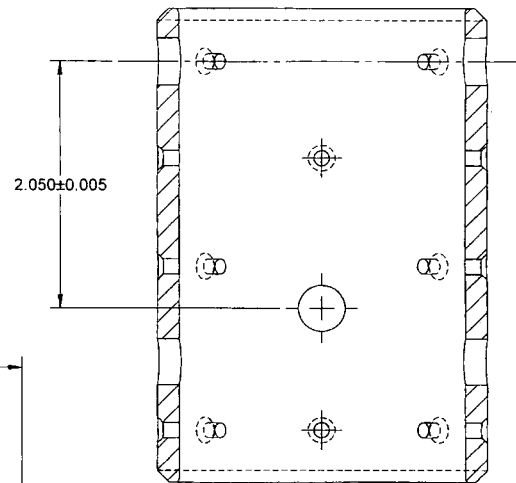
WORK ORDER NON-CONFORMANCE (NCR)

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NOTE: Date & initial all entries

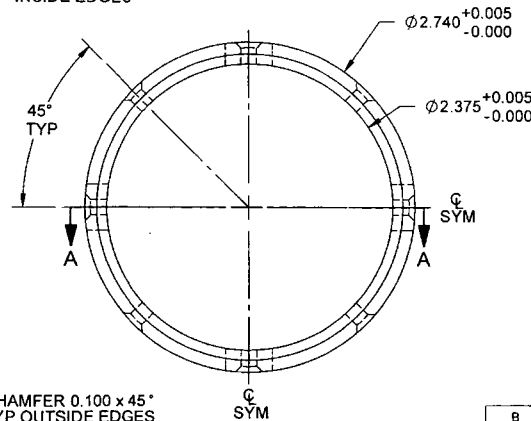
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 75173 M.C.J
11/10/18



SECTION A-A

R0.032 TYP
INSIDE EDGES



CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES

D3659-1 CUFF

DRILL #30 (Ø0.128 REF)
C'SINK Ø0.230x100°
TYP 22 PLACES



Ø0.386+0.005
-0.000
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TYP 6 PLACES



NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (VV-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6005, D6006, D6008, D6009, D6011, OR D6019)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 lbs

B	ADD Ø0.128 & Ø0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>P</i>		
CHECKED	<i>H</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D3659	SHEET 1 OF 1
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>H</i>	CUFF	NTS
DATE	08.03.03	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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